Dart Aerospace Ltd. Wednesday, 10/31/2007 3:26:07 PM 23.07 User: **Process Sheet** : TUBE **Drawing Name** Customer : CU-DAR001 Dart Helicopters Services Job Number : 35473 **Estimate Number** : 11175 Alu: Part Number : D22825 P.O. Number : D2282 REV E : 10/31/2007 **Drawing Number** This Issue : N/A : NC Project Number Prsht Rev. : MACHINED PARTS **Drawing Revision** First Issue : 34182 Material Previous Run Each Due Date : 11/30/2007 Written By Checked & Approved By Removed from 9 Digit 05-12-02 JLM Comment : Est Rev:Á **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: 1.0 M304RO750 Inventory Comment: Qty.: .18.9063 f(s) 23 , 5000 0.1891 f(s)/Unit Total: Material: AISI 304 Stainless Steel Ø0.750(M304R0.750) Batch M 106317 -), 2.0 HARDINGE Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Dwg D2282 and Folio FA189 2-Deburr QC2 INSPECT PARKS AS THEY COME OFF MACHINE 3.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE CONVENTIONAL MILLING MACHINE 4.0 MILLING CONV Comment: CONVENTIONAL MILLING MACHINE Mill Arc as per Dwg D2282 INSPECT PARTS AS THEY COME OFF MACHINE 5.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE

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W/O: WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:	PAR #:	_ Fault Category:	NCR: Yes No DQA:	Date: <u> </u>
			QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	Annroyal	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section Ø	Approval Chief E	
01.12.01	4.0	Bulz monog rpije		Scropereplace etyl3 M_106317	51 04.12.03	11.		
		RC: pm+s turned/shifted	Posicus		04.12.03		/05/012	1A12.05
		while vised i vibrated.						
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NOTE: Date & initial all entries

Wednesday, 10/31/2007 3:26:07 PM Date: User: Kim Johnston **Process Sheet Drawing Name: TUBE** Customer: CU-DAR001 Dart Helicopters Services Part Number: D22825 Job Number: 35473 Job Number: Description: Seq. #: Machine Or Operation: SECOND CHECK 6.0 QC8 Comment: SECOND CHECK PACKAGING 1 PACKAGING RESOURCE #1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 8.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion WA11204

Dart Ae	rospace L	.td							
N/O:		****	V	VORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector

Part No	:	PAR #:	Fault Ca	tegory: NC					
NCR:	-		WORK OR	DER NON-CONFORMANCE			a:	Date:	· · · · · · · · · · · · · · · · · · ·
		Description of NC		Corrective Action Section B		Vorifi	cation	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Approval Chief Eng	Approval QC Inspector
	1								
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35473
Description: Handle Tube	Part Number:	D2282-5
Inspection Dwg: D2282 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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			<u> </u>			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.17	+/-0.030	2.188	1			
R0.063	+/-0.010	e063				
0.063	+/-0.010	1063	/			
0.125	+/-0.010	1/24	1			
0.090 x 45°	+/-0.010	1085×45				
R0.350	+0.010/-0.000	12,350				
0.158	+/-0.010	-159	/			
Ø0.386	+0.005/-0.000	.388				
. 700	4/-010.	7001	#			
2		-701				
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	375	te				

Measured by: Audited by:	Prototype Approval:	N/A
Date: 0/11/23/01/11/25 Date: 07/10/0	Date:	N/A

Rev	Date	Change	Revised by	Approved
·A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
В	05.04.19	Dimensions & tolerances changed	KJ/JLM , ,	-1
С	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM C	

07-11-2

				1. Selectification
	DESIGN BW	DRAWN BY	DART AEROSPA HAWKESBURY, ONTARIO	ACE LTD
DATT	CHECKED	APPROVED	DRAWING NO. D2282	REV. E SHEET 1 OF 2
	DATE 05.06.07	1 (124)	TITLE HANDLE TUBES	SCALE 1:1
0	Α	94.10.14	NEW ISSUE	
DELXASER	В	95.03.23	RE-DESIGN	
	С	97.10.20	CORRECTED NUMBERING	SCHEME
05/09/16	D	05.03.16	REDESIGN D2282-5; 0.7	95 WAS 0.750
89011	E	05.06.07	D2282-5 304 SS WAS R0.063 x 0.063 WAS R0	303 SS;).080 x 0.030
2.375_0.000	-	0.795	Ø0.493	− Ø0.675 (REF)
D2282-3	D	D2282-	(RFF)	
D2282-3/-7 TUBE:	/R SCHEDI	IIIE 40 (REE	DART SPEC M304TR0 675	.w 091)

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED R0.063 x 0.063 DEEP 4 $0.090 \times 45^{\circ}$ 0.95 -CHAMFER 0.158 Ø0.700 R0.350 ø0.386^{ОР СОРУ} 0.125 RETURN TO $0.080 \times 45^{\circ}$ ENGINEERING (REF) UNCONTROLLED COPY **CHAMFER** SUBJECT TO AMENDME WITHOUT NOTICE D2282-5

D2282-5 STEM:

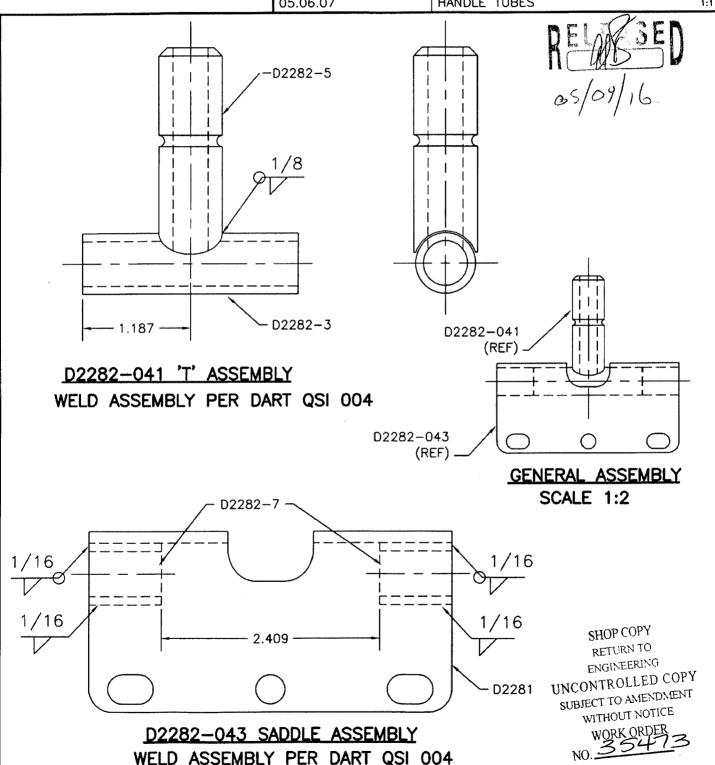
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN BW	DRAWN BY	DART AEROS HAWKESBURY, ONT	· · ·
CHECKED	APPROVED	DRAWING NO.	REV. E
u'	1 1115	D2282	SHEET 2 OF 2
DATE		TITLE	SCALE
05.06.07		HANDLE TUBES	1:1



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